

**Work Order ID 53236**

Page 1

October 28, 2009 8:31:48 AM

Item ID: D2580-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 28/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

B1

Date: 09-10-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100



HandFinish

Memo

0.00

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.

2- Chemical Conversion Coat as per QSI 005 4.1

101



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

2 - - AWM9-11-5

2 49/11/6

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Page 2

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Item ID: D2580-1

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Setup Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 28/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Skidtubes

Memo

0.00

2

Awr9-105

Skidtubes

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

□□

A/R Sikaflex-291 batch: \_\_\_\_\_

M112391

Sikaflex expire date: \_\_\_\_\_

10-2-20

Start time: \_\_\_\_\_ bond for 12hrs

130



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

2780006

(X2)

f

**Work Order ID 53236**

Page 3

October 28, 2009 8:31:48 AM

Item ID: D2580-1

Accept



Setup

Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 28/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

140



Identify as per dwg &amp; Stock Location:

L.G

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Memo

0.00

2

-

-Awm 21-06

150



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/06 HJ

MF  
09-11-06

# Picklist Print

October 28, 2009 8:31:54 AM

Page 1

Work Order ID: 53236



Parent Item: D2580-1RevD



Parent Item Name: 205 Skidtube bent detail

Start Date: 28/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevG		Manufactured		No			Each	144.0000	2.0000			

Ext'n - T Beam Tube 4"



## Warehouse

### Location

#### Main Warehouse

LG	141
50166	40
52319	101

*AWM 9-11-05*

#### Main Warehouse

ST	3
46468	3

*\_\_\_\_\_*

D2596RevD



Manufactured

No

110

Each

8.0000 2.0000



Web, 205 Skidtube

## Warehouse

### Location

#### Main Warehouse

LG	8
51528	8

*(1)*

*AWM 9-11-05*

*B-53263 AWM 9-11-05 (1)*

**DART**

DESIGN <i>#</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *#*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

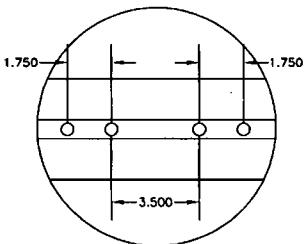
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NO. *53236*  
*B109-10-2F*

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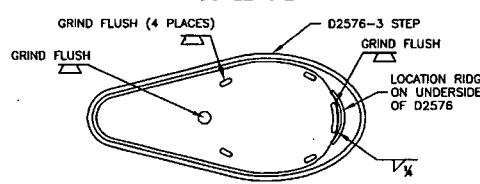
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DETAIL A  
SCALE 5:24

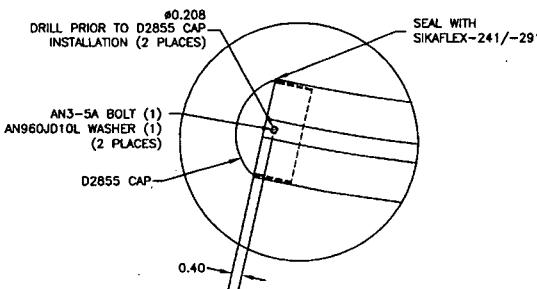


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07-06-28-01

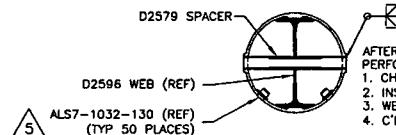
DETAIL B  
SCALE 5:24



DETAIL C  
SCALE 5:24



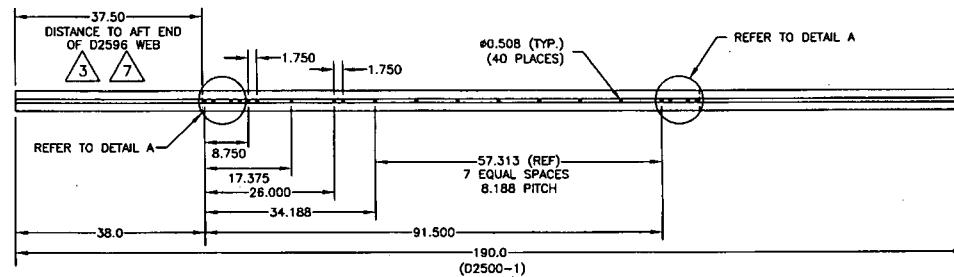
SECTION D-D  
SCALE 5:24



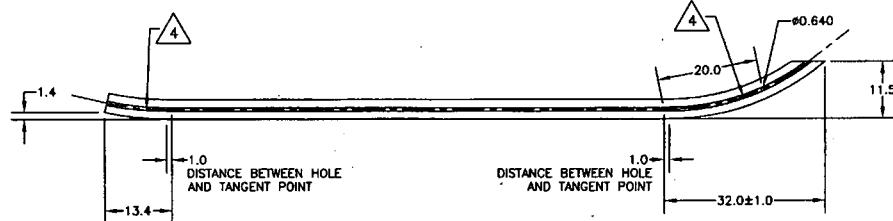
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. CBORE D2579 SPACER TO #0.437 X 1.00 DEEP

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NO. 53236

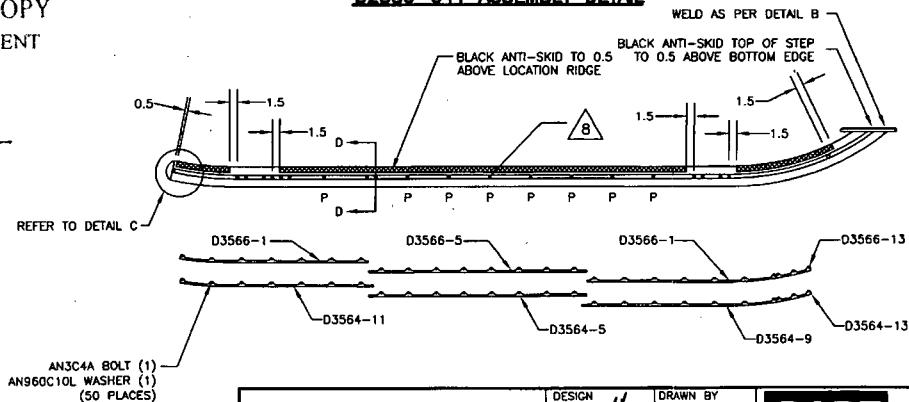
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



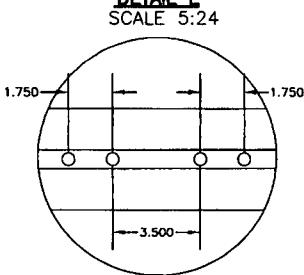
D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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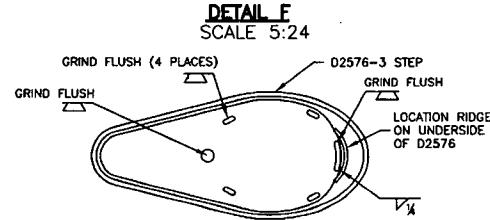
DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED		REV. D D2580 SHEET 2 OF 3
DATE			SCALE 07.02.27 205 SKIDTUBE ASSEMBLY
			1:24



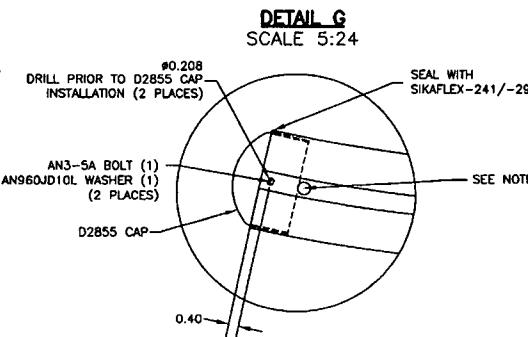
DETAIL E  
SCALE 5:24

A circular diagram representing a part. The top and bottom horizontal diameters are labeled 1.750. The total width of the part is labeled 3.500. Four small circles are positioned on the bottom horizontal diameter.

RELEASED  
07-06-28 4

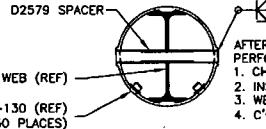


DETAIL F  
SCALE 5:24



DETAIL G  
SCALE 5:24

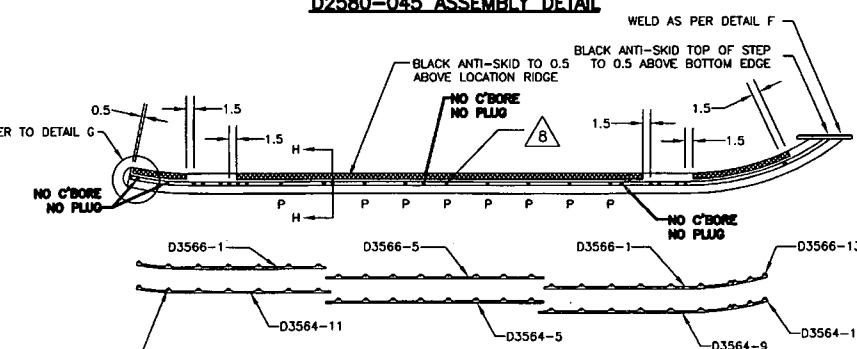
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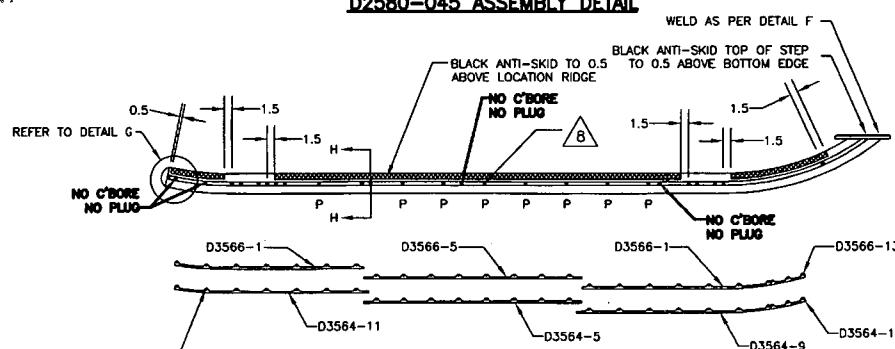
**SECTION H-H**  
SCALE 5:24

D2596 WEB (REF)

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO  $0.437 \times 1.00$  DEEP



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

